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D4030-041
Job Sheet 185883



Part No: D4030-041

Job Qty: 1 ea

Part Name: Long Basket Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEETS 1,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Stores/Pkg-1		ML 18-12-03
100	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging1-4		ML 18-12-03
110	HandFinish	1 pcs	12/7/18	12/7/18	0.00	1.03	HandFinish4		ML 18-12-03
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		DEC 05 2018
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2	DEC 06 2018	DEC 05 2018
140	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		DEC 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A 15A	Bolt	4 Ea (4 ea)	90-Start up Operation	5130323
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5089276
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5121225
AN310C4	Nut	2 Ea (2 ea)	90-Start up Operation	5103957
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5113819
AN5-17A	Bolt 5112904(xu)	4 Ea (4 ea)	90-Start up Operation	5115080
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5121157
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5115452
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5124370
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5117415
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5108609
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5112717
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5118041
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5115826
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5115399
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5117430
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5094592
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5083541
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5053951
MS24665-151	Cotter Pin	3 Ea (3 ea)	90-Start up Operation	5104465
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5050032-1
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5109991
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : 18/12/13		Step #:		QTY Effective :			MRB (QSI042) Approval INSP 12 QP 18/12/13																		
Description Work Order Deviation				Disposition				Completed By QP 18/12/13																	
AN3-14A too short, not enough threads in safety.				Acceptable to use AN3-15A per QSI 042				Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

NAS1149F0432P	Washer	6 Ea (6 ea)	90-Start up Operation
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation
D3913-041	Long Basket Base Assembly, 350	1 Ea (1 ea)	110-HandFinish
D3914-041	Long Basket Lid Assembly (350)	1 Ea (1 ea)	110-HandFinish

5083558-1
5067901-2
5132452
5181985

Job Allocations

006877

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-14A	4	302	0
	AN3-16A	2	76	0
	AN310-4	3	202	0
	AN310C4	2	93	0
	AN4-12	3	161	0
	AN5-17A	4	85	0
	D2530	1	9	0
	D2535	2	51	0
	D2537	2	32	0
	D3917-3	6	106	0
	D3953-17	2	39	0
	D3953-19	1	28	0
	D3953-21	1	15	0
	D3953-3	2	28	0
	D3953-7	2	100	0
	D3953-9	2	34	0
	D3969-3	1	8	0
	MS21042L3	6	2,097	0
	MS21042L5	4	479	0
	MS24665-151	3	139	0
	MS24665-300	2	81	0
	NAS1149C0432R	2	1,914	0
	NAS1149F0332P	8	1,879	0
	NAS1149F0432P	6	1,248	0
	NAS1149F0563P	4	725	0
110-HandFinish	D3913-041	1	0	0
	D3914-041	1	3	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

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Plex 11/6/18 11:17 AM Dart.lajeunesse.marie

Container No: S134180



Part: D4030-041

Job No: 185883

Serial No/Batch: S134180

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/03/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					